

Date: Friday, 14/11/2008 10:20:59 AM  
User: Julie Dawson

## Process Sheet

SRPT

Customer : CU-DAR001 Dart Helicopters Services  
Job Number : 43444  
Estimate Number : 10255  
P.O. Number :  
This Issue : 14/11/2008 S.O. No. :  
Prsht Rev. : NC  
First Issue : 11 Type : MACHINED PARTS  
Previous Run : 41819  
Written By :  
Checked & Approved By : JUO 08.11.14  
Comment : Est D 00.11.01 Added inspection level 8, and removed P/O for powder coat EC

Drawing Name : MOUNTING LUG  
Part Number : D22301  
Drawing Number : D2230 REV F  
Project Number : N/A  
Drawing Revision : F  
Material :  
Due Date : 10/12/2008  
Qty: 200 Um: Each

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D2423 Lug Extrusion



Comment: Qty.: 0.0717 f(s)/Unit Total : 14.3430 f(s)  
Lug Extrusion D2423 Extrusion  
Batch: 43722

2.0 BAND SAW BAND SAW



Comment: BAND SAW  
Cut D2423 extrusion to 0.82"  
Batch: 43722

Cut @ 4 meters

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1  
1-Machine per folio D2230-1  
(Check for crack while loading into the machine.)  
2-Tumble and deburr rough edges after tumbling

issue 710. 7604 meters

200

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.0 QC2 SECOND CHECK

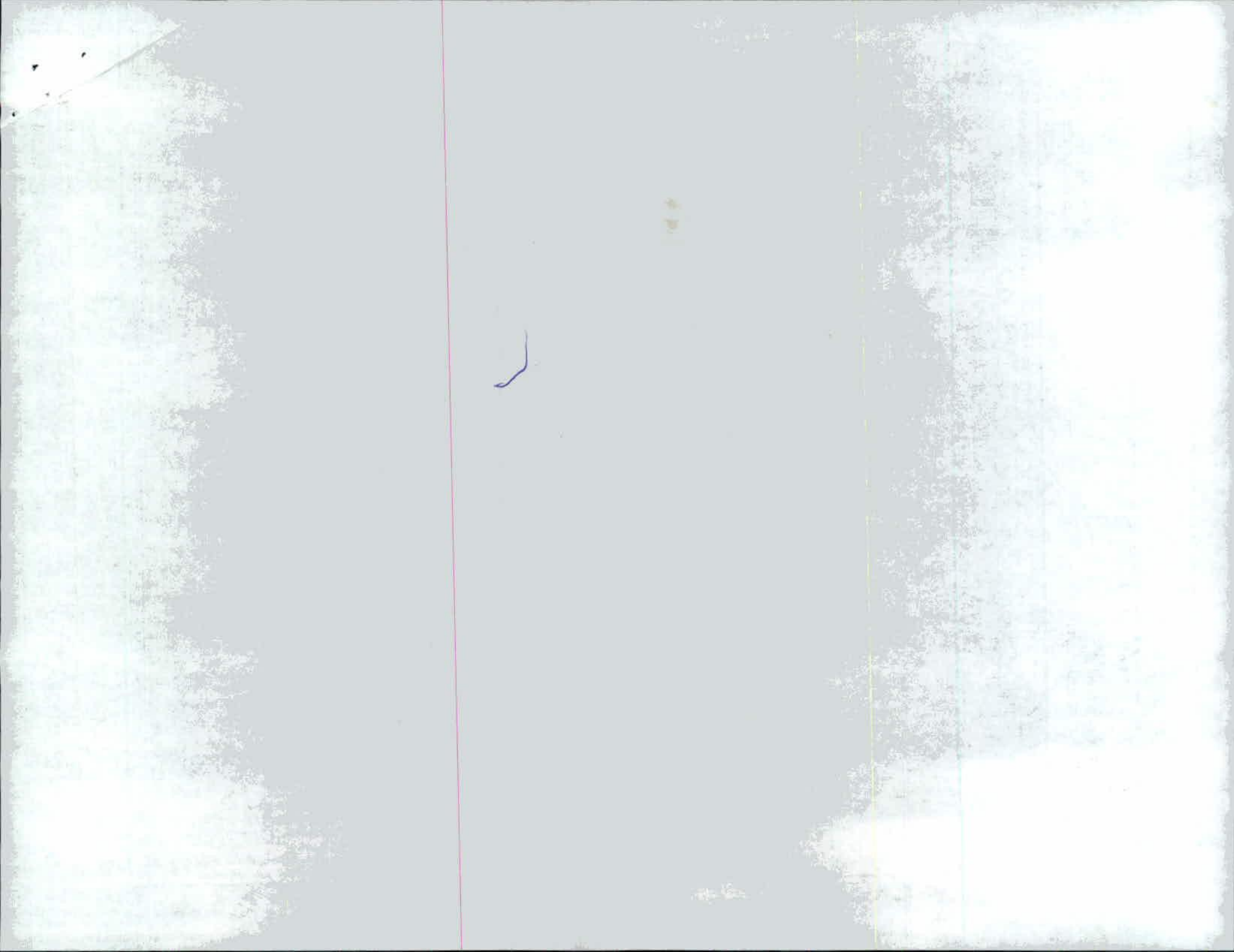


Comment: SECOND CHECK

808/10/18

counter

200





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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MOUNTING LUG

Job Number: 43444

Part Number: D22301

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



(101)

Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

FX 08/12/18

7.0

QC5

INSPECT WORK TO CURRENT STEP



counter

Comment: INSPECT WORK TO CURRENT STEP

S 08/12/18

x/2

8.0

POWDER COATING

POWDER COATING



(101X)

Comment: POWDER COATING

Powder Coat Gloss White (ref. 4.3.5.1) per Dart QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

8:00  
320°F  
8:30

m-l 08/12/19

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(101)

Comment: INSPECT POWDER COAT

FX 08/12/19

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: CA

SB 08/12/23

(101)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



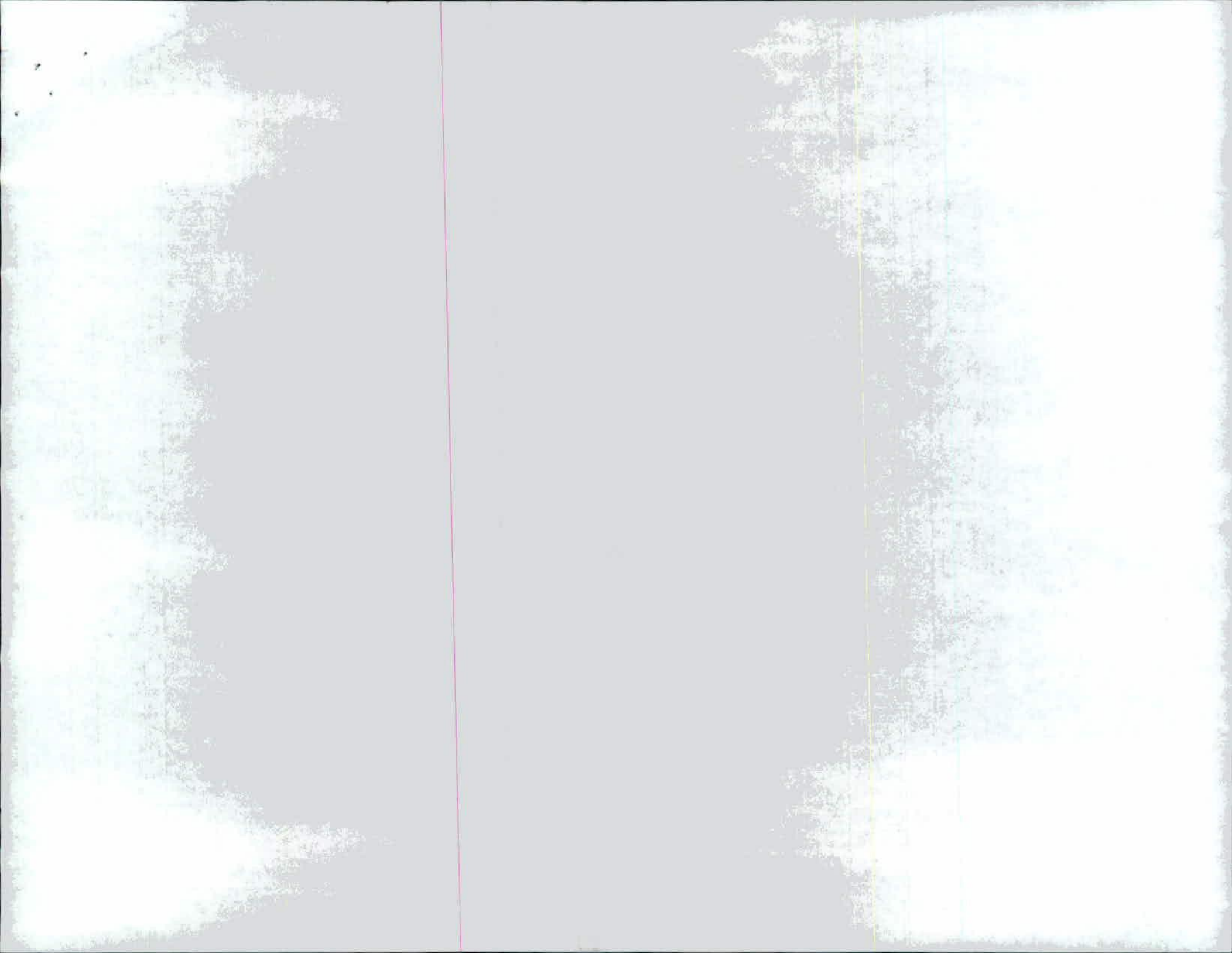
08/12/24

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-12-23

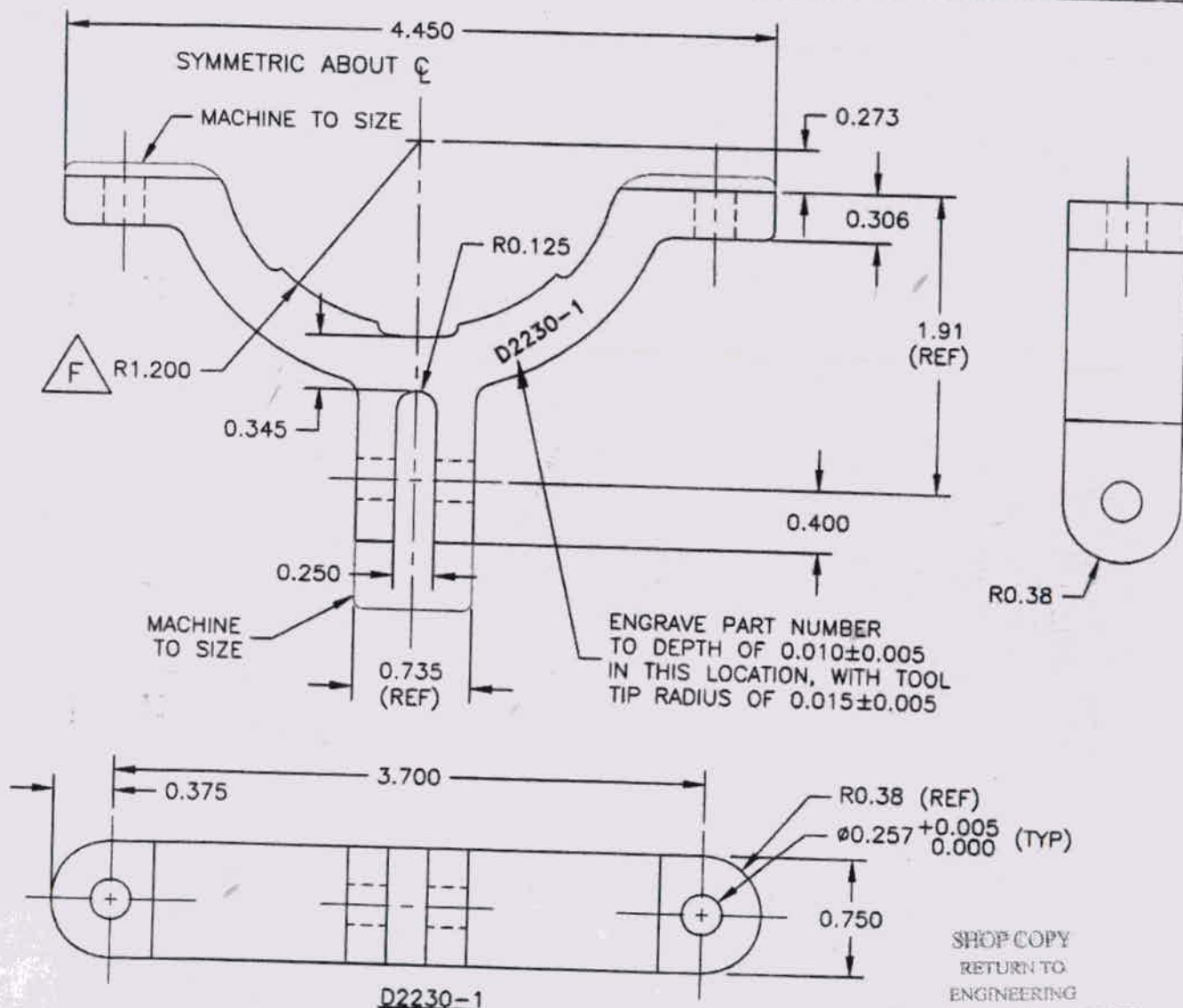






RELEASED  
19-12-21 DS

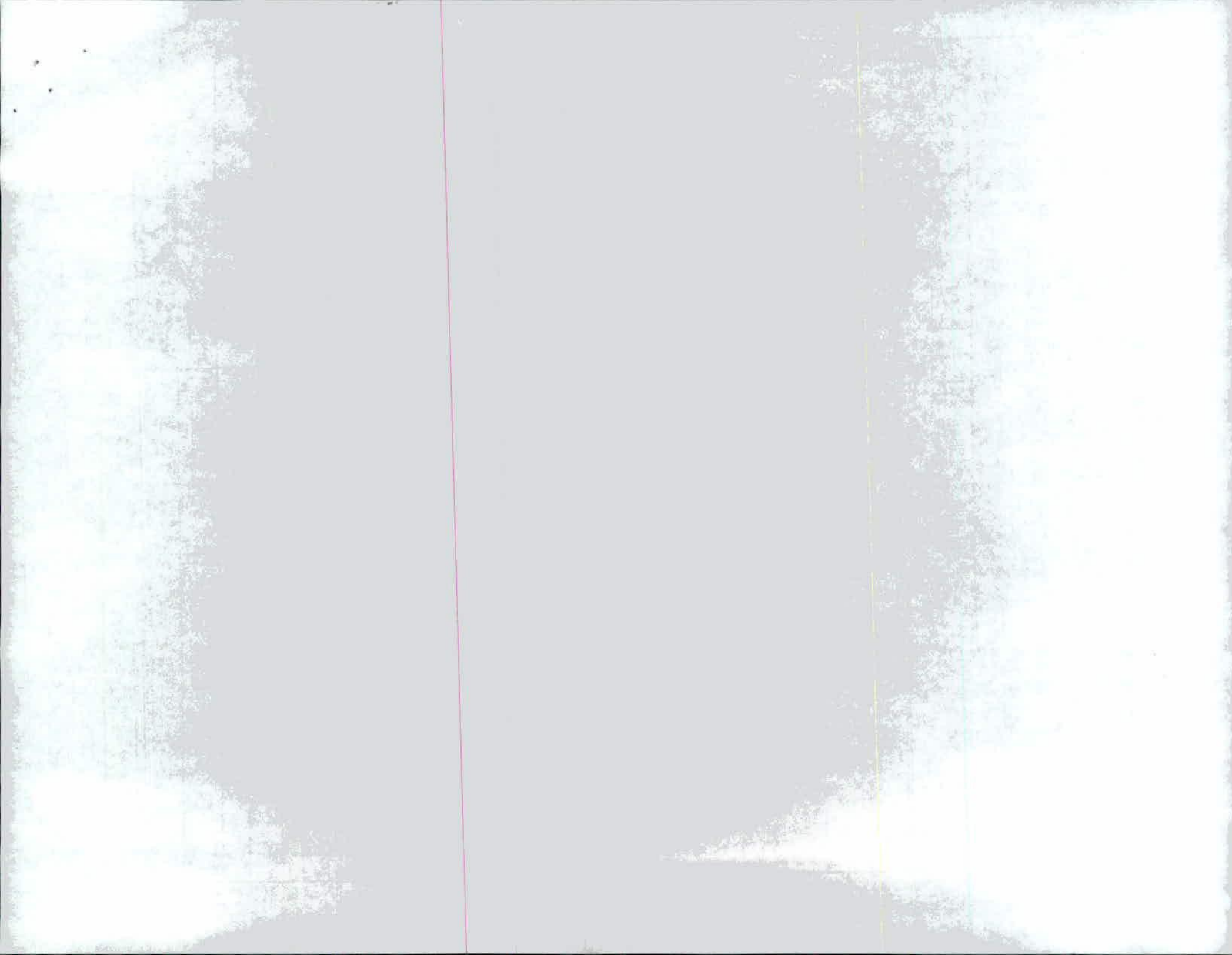
DESIGN <i>CP</i>		DRAWN BY <i>CP</i>		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>		APPROVED <i>[Signature]</i>		DRAWING NO. D2230	
DATE 99.12.13		TITLE MOUNTING LUG		REV. F SHEET 1 OF 2	
C	94.03.30	RE-DESIGN			
D	95.01.04	RE-DESIGN			
E	95.01.04	RE-DESIGN			
F	99.12.13	REDESIGN; R1.200 WAS R1.100			



MAKE FROM EXTRUSION D2423  
BREAK ALL EDGES 0.000-0.015  
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY  
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WITHOUT NOTICE  
WORK ORDER  
NO. 424114

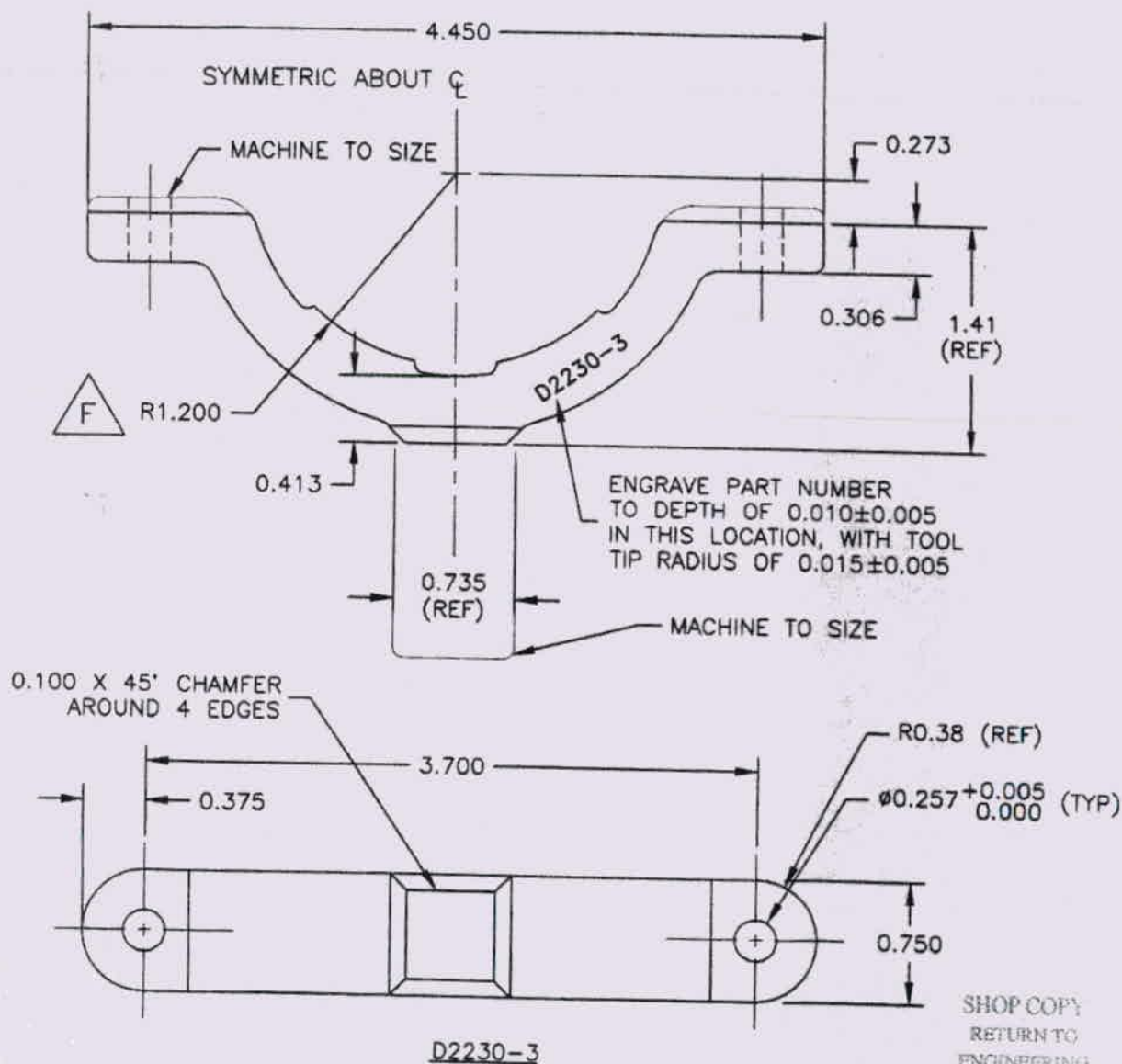
NO. 43744





DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED		APPROVED		DRAWING NO. D2230
DATE	99.12.13	TITLE	MOUNTING LUG	REV. F SHEET 2 OF 2
				SCALE 1:1

RELEASED  
79.12.21 DS



MAKE FROM EXTRUSION D2423  
BREAK ALL EDGES 0.000-0.015  
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY  
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ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 43444





## CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, Ont.  
K6A 1K7

SHIPPED TO:

same

QUANTITY

PART NUMBER

PART NAME

P.O. NUMBER

101

D2230-1

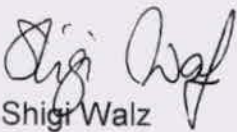
Mounting lug

7604

MATERIAL: supplied by DART D2423 B43722

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

  
Shigi Walz

  
08/12/18

Vankleek Hill, December 18, 2008



